

Date: Monday, 18/08/2008 4:05:12 PM
 User: Julie Lecocq

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DECK PLATE KIT
 Job Number : 41359
 Estimate Number : 11233
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350616015
 First Issue : 18/08/2008 Type : SMALL /MED FAB Drawing Number : D350-616 REV D
 Previous Run : 39602 Drawing Revision : D
 Material :
 Due Date : 10/09/2008 Qty: 3/PO 4 Um: Each
 Written By :
 Checked & Approved By : JLD 08.8.18
 Comment : Est Rev:C Removed Manufacturing 05-12-05 JLM
 Est Rev:D Add D3494-1 05-12-05 JLM
 Est rev E added parts per NCR 08-041 08.04.30 EC
 verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.8.26



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D350-616-015 CHG002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2344 Litter Deck Plate, 350



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft) 1238810 SP

4.0 D2348 Wearplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way) 1339578 8/9/4 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:05:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 41359

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2353

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener

B39639

SP

6.0

D2364

Deck Plate, Fwd 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd)

B39239

B41123 2x 18/12/08

SP

7.0

D2365

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin)

B38331

New batch
B41124 x2 18/08/08

SP

8.0

D23691

Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate

B38812

8/9/08 SP
B41125

SP

9.0

D23693

Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate

B39640

SP

10.0

AN960JD10

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 AN960JD10

Washer

M109059

8/9/08

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 41359

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS20426AD45

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet M3459

50

12.0

MS20426AD46

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet M10514

50

13.0

MS20426AD57

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet 7681

518

14.0

MS20426AD58

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet M4533

50

15.0

MS20601AD4W2

Rivet



Comment: Qty.: 15.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet M108244

②

M19454

8/9/4

4x

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 41359

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS20601AD4W3

Rivet



Comment: Qty.: 30.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet

M107534

(62)
(28)
M107823

SP

17.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3)

M108701

SP

18.0

MS24693C48

Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total: 88.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48)

M104215

SP

19.0

MS24693C273

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273Screw (or -273)

M107394

SP

20.0

D34941

Stub Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

STUB COVER

Batch:

B338900

B338900

8/9/4

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 41359

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS35207264

Screw



(4x)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Screw

batch: M104959

8/9/4

50

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

w/o split.

23.0

PACKAGING 1

PACKAGING RESOURCE #1



(3x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location: 31A

PPP Rev: C

8/10/8

50

24.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.10.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION SCALE NTS	
A	95.02.20	NEW ISSUE	
B	96.01.09	ADD VIEW OF D2493 TO SHEET 9	
C	06.01.10	ADD DSI 9112/9117/9130/9236/9310	
D	06.01.19	ADD D3494-1 STUB COVER	

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
	1		D2350	LITTER TIE DOWN (NON-LOCKING)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
		1	D3494-1	STUB COVER
		10	AN960JD10	WASHER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (OR CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (OR CR9162-4-3)
		22	MS24693-C48	SCREW (OR MS24693-48)
		6	MS24693-C273	SCREW (OR MS24693-273)
		6	MS21042L3	NUT (OR MS21042-3)
		4	MS35207-264	SCREW

SHOP COPY
RETURN TO
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WORK ORDER
NO. 41359

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
CERT. NO.:	SH96-10
ISSUE NO.:	2

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION SCALE NTS	

GENERAL NOTES:**1. COMPATIBILITY**

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011	31.3 lb	17.3 in	541.5 in-lb	63.8 in	1996.9 in-lb
Full Litter Kit	14.19 kg	0.44 m	6.24 m-kg	1.62 m	22.99 m-kg
D350-616-013	6.3 lb	15.4 in	97.0 in-lb	52.0 in	327.6 in-lb
Deck Plate & Tie Down	2.86 kg	0.39 m	1.12 m-kg	1.32 m	3.78 m-kg
D350-616-015	2.8 lb	15.6 in	43.7 in-lb	53.0 in	148.4 in-lb
Deck Plate Kit	1.27 kg	0.40 m	0.51 m-kg	1.35 m	1.71 m-kg
Person Approximate CG	lb	18 in	in-lb	72 in	in-lb
	kg	0.46 m	m-kg	1.88 m	m-kg

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BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

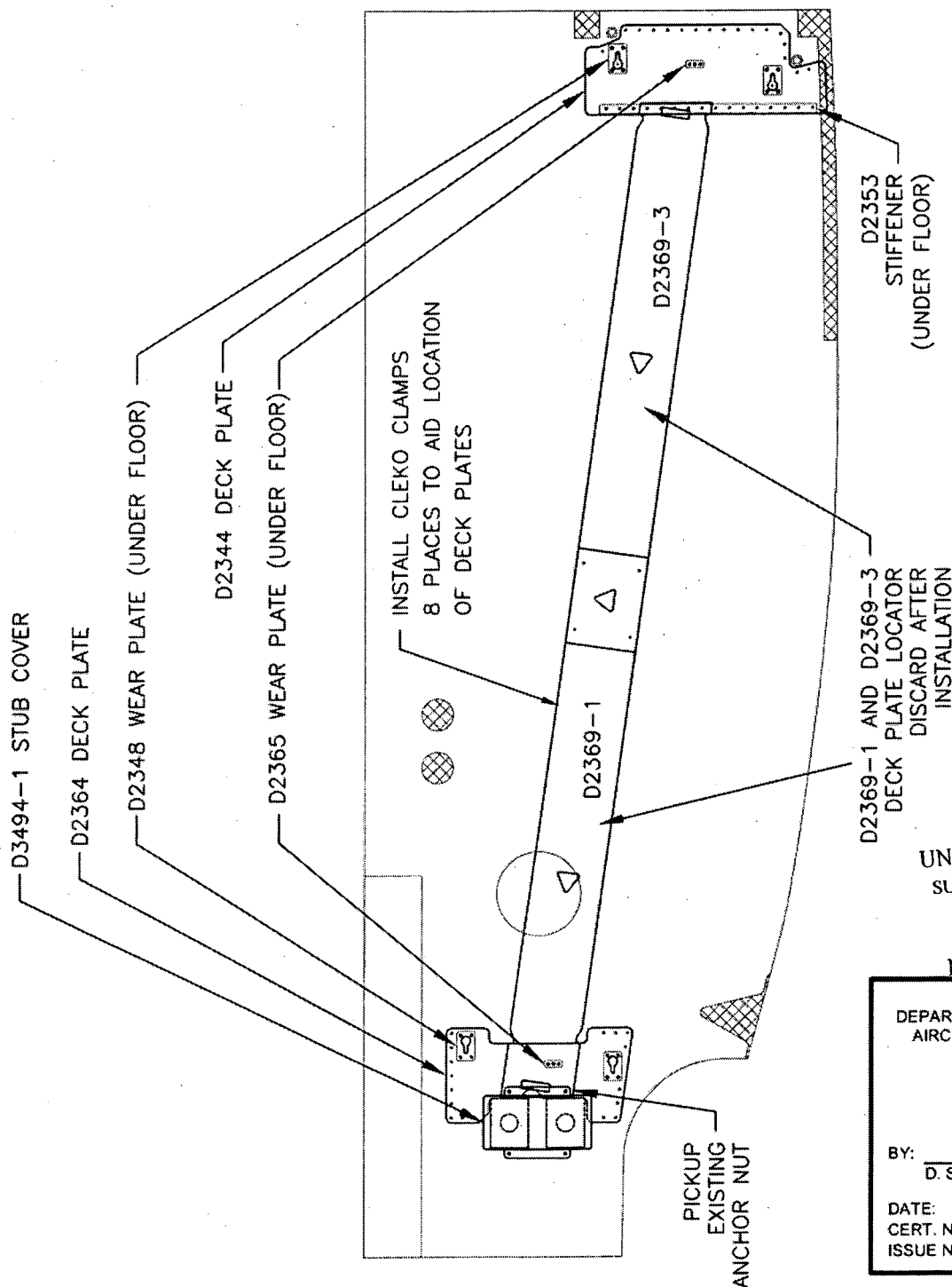
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DATE 06.01.19	TITLE AS350/355 LITTER INSTALLATION		SCALE NTS

**FIGURE 1**

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

PICK UP ON EXISTING RIVETS
USE MS20601AD4W3 (CR9162-4-3)
OR MS20426AD4-6

MS24693C48
(10 PLACES)

INBOARD
FWD

EXISTING SCREW

D2348 AND D2365
MS24693-C48
(UNDER FLOOR)

FOR HELICOPTERS WITH
LARGE NOSE WINDOWS
PICK UP ON EXISTING RIVETS
USE MS20601AD4W3
(CR9162-4-3)
OR MS20426AD4-6

FOR SMALL NOSE WINDOW
SEE DETAIL A

MS20601AD4W2 (CR9162-4-2)
OR MS20426AD4-5
(14 PLACES)

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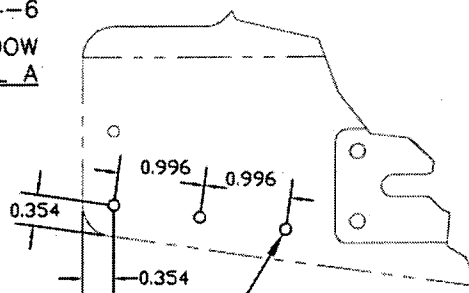
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FIGURE 2



DRILL AND INSTALL
USE MS20601AD4W2
(CR9162-4-2)
OR MS20426AD4-5

DETAIL A

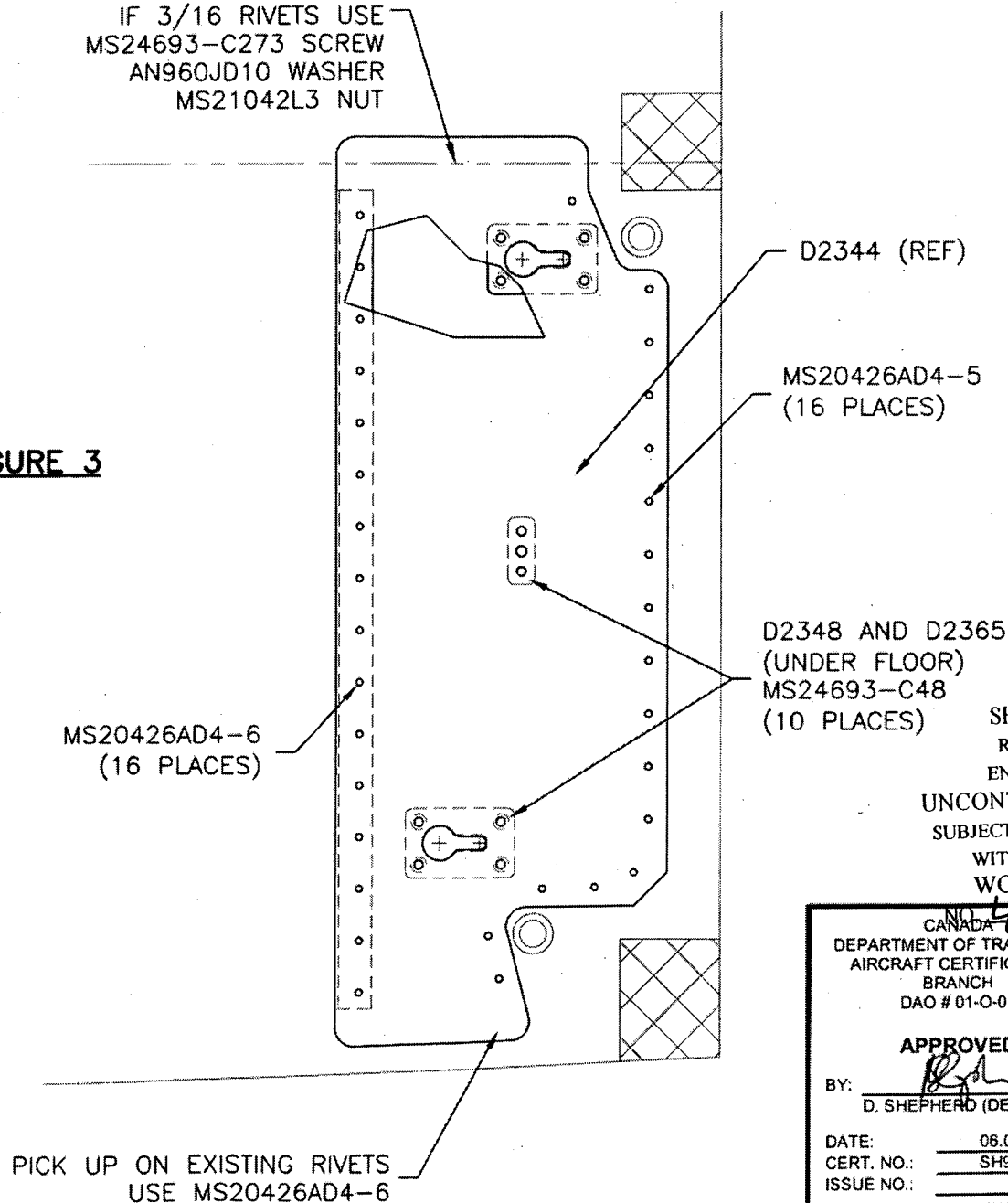
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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

PICK UP ON EXISTING RIVETS
IF 5/16 RIVETS USE
MS20426AD5-7/MS20426AD5-8
IF 3/16 RIVETS USE
MS24693-C273 SCREW
AN960JD10 WASHER
MS21042L3 NUT

FIGURE 3

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DAO # 01-O-01	
APPROVED	
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

FIGURE 4: LITTER TIE DOWN INSTALLATION

D3494-1 STUB COVER
PICK UP ON EXISTING INSERTS:
USE EXISTING SCREWS OR
MS35207-264 SCREWS (4)
AND AN960JD10 WASHERS(4)

D2350
LITTER TIE DOWN
(NON-LOCKING)

D2360
LITTER TIE DOWN
(LOCKING)

INBOARD

FORWARD
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WORK ORDER
NO. 41359

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DEPARTMENT OF TRANSPORT
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BY: [Signature]
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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

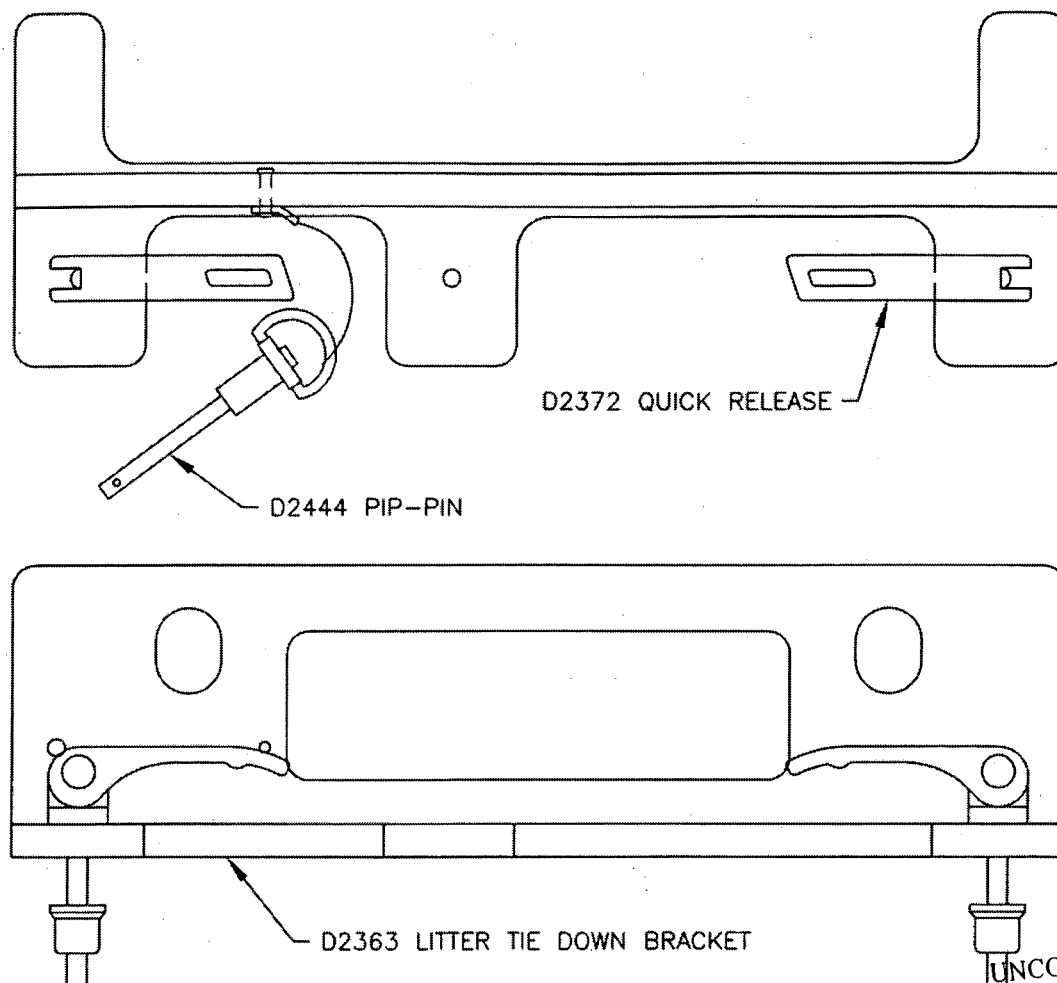


FIGURE 5: D2350 LITTER TIE DOWN ASSEMBLY
(PART REFERENCE)

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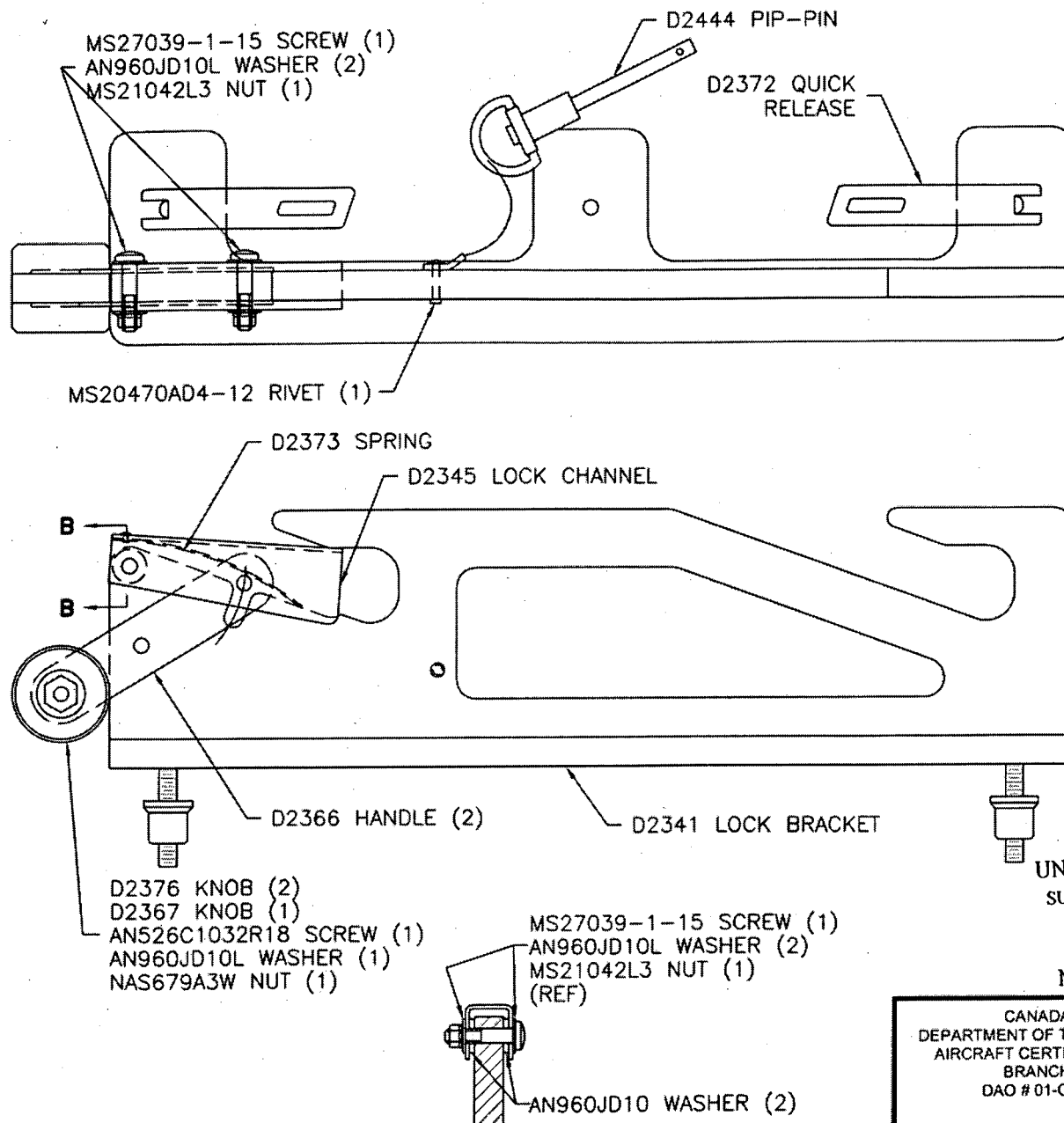
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BRANCH	
DAO # 01-O-01	
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS



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NO. 41359

SECTION B-B

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

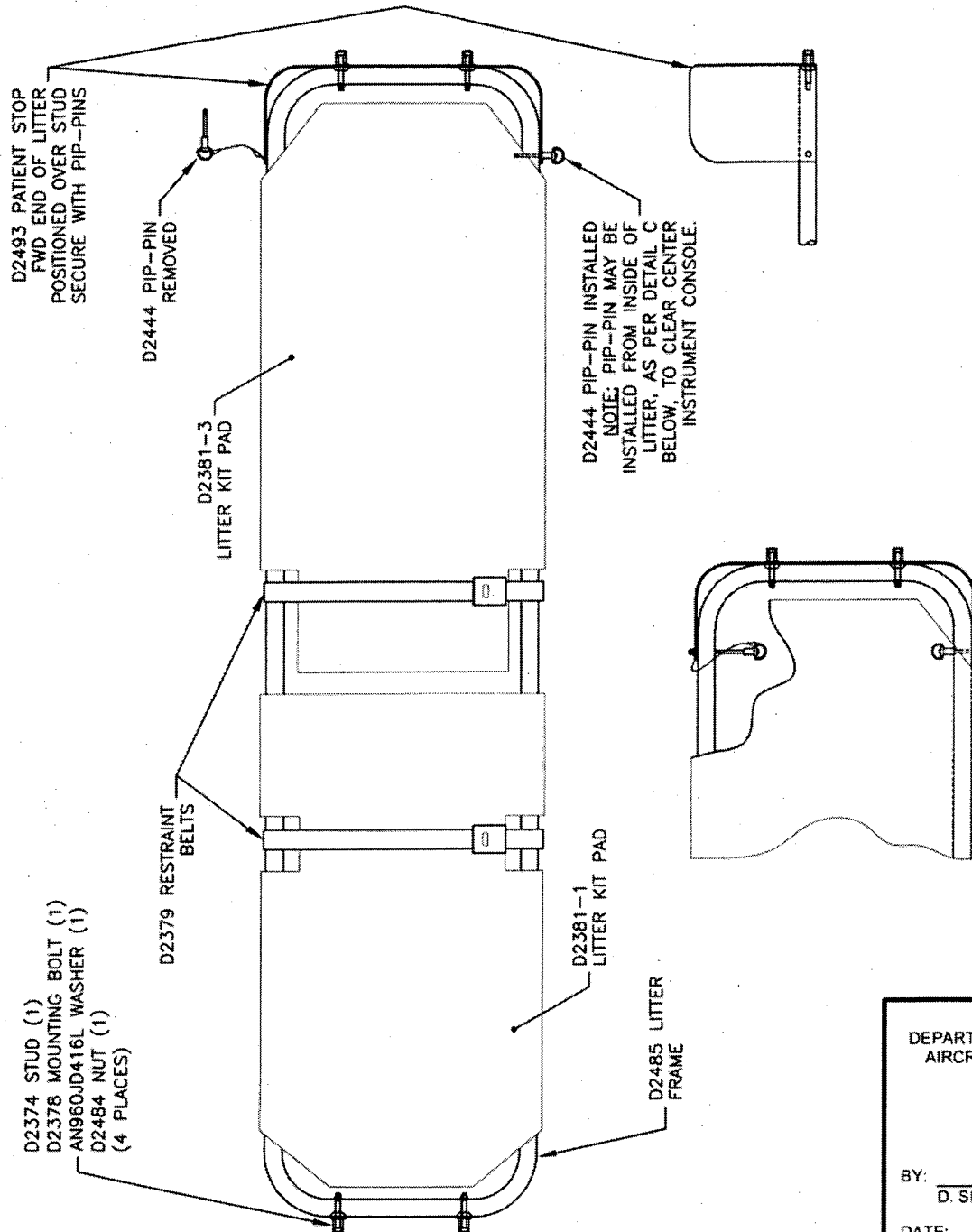


FIGURE 7: D2370 LITTER ASSEMBLY
(PART REFERENCE)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.01.19
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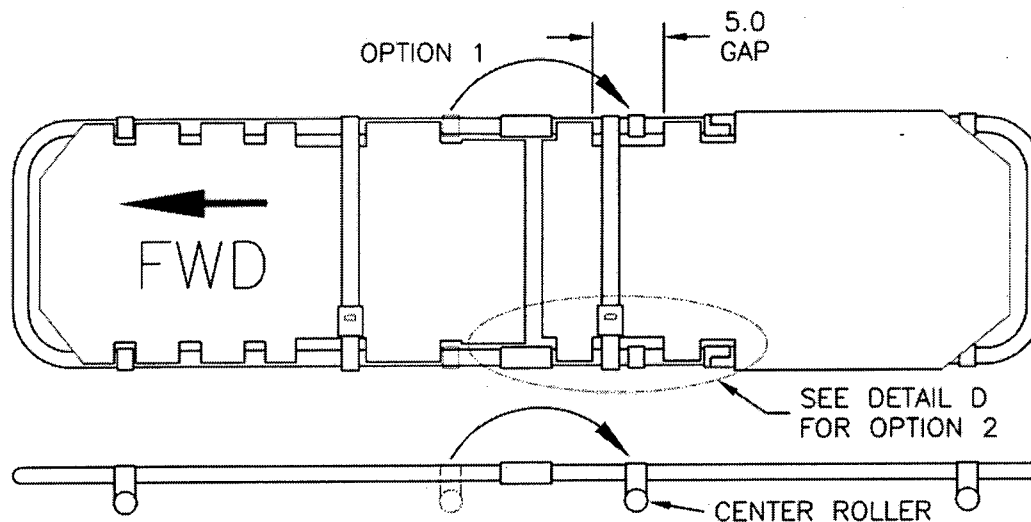


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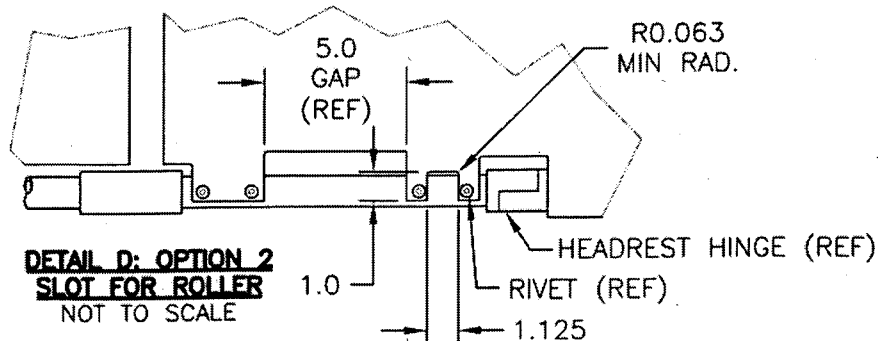
COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.



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FIGURE 8: CENTER ROLLER RE-LOCATION

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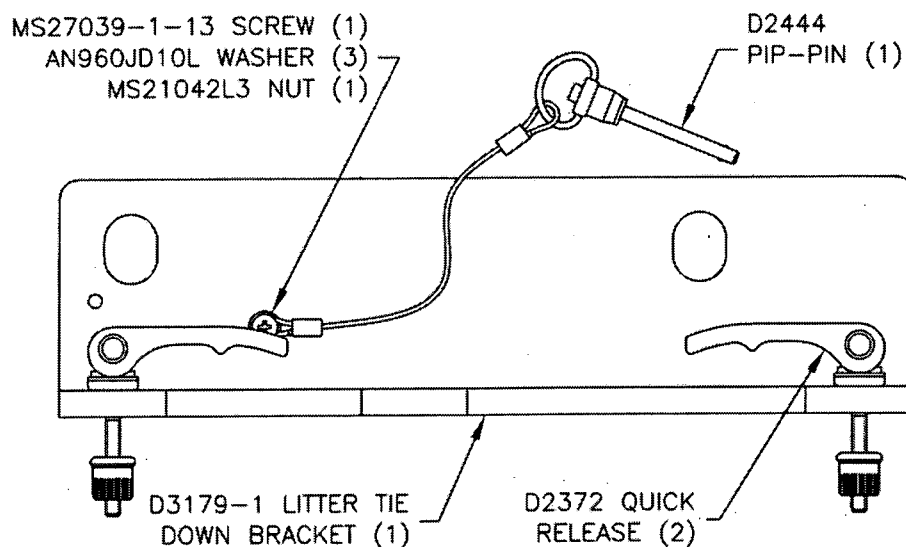
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COMPATIBILITY WITH GENEVA CONSOLE

FWD LITTER TIE DOWN BRACKET D3179-041 CAN BE USED IN LIEU OF D2350 LITTER TIE DOWN BRACKET REFERRED TO IN THE PARTS LIST FOR COMPATIBILITY WITH THE GENEVA CONSOLE. TO ASSEMBLE D3179-041, ORDER D3179-1 FROM DART AND TRANSFER HARDWARE FROM D2350 AS SHOWN BELOW. IT IS ACCEPTABLE TO TRIM D3179-1 AS REQUIRED FOR FIT AS LONG AS A MINIMUM EDGE DISTANCE OF 0.250" IS MAINTAINED FROM THE EDGE OF ALL HOLES AND SLOTS. PRIME AND PAINT IN ACCORDANCE WITH THE AIRCRAFT MAINTENANCE MANUAL PRIOR TO FINAL INSTALL.



**FIGURE 9: D3179-041 FWD
LITTER TIE DOWN**

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COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 10 & 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 11.

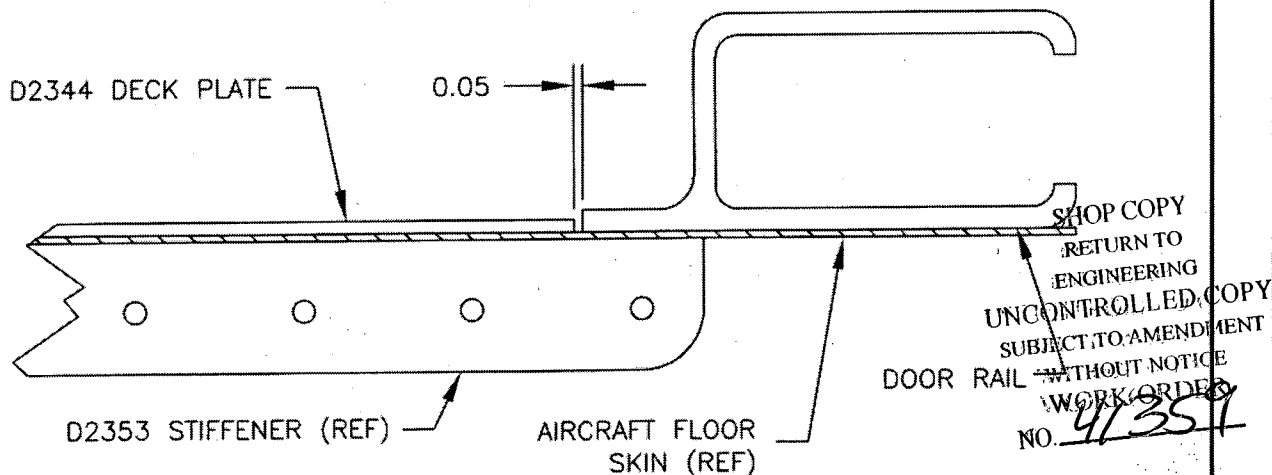


FIGURE 10
VIEW LOOKING AFT

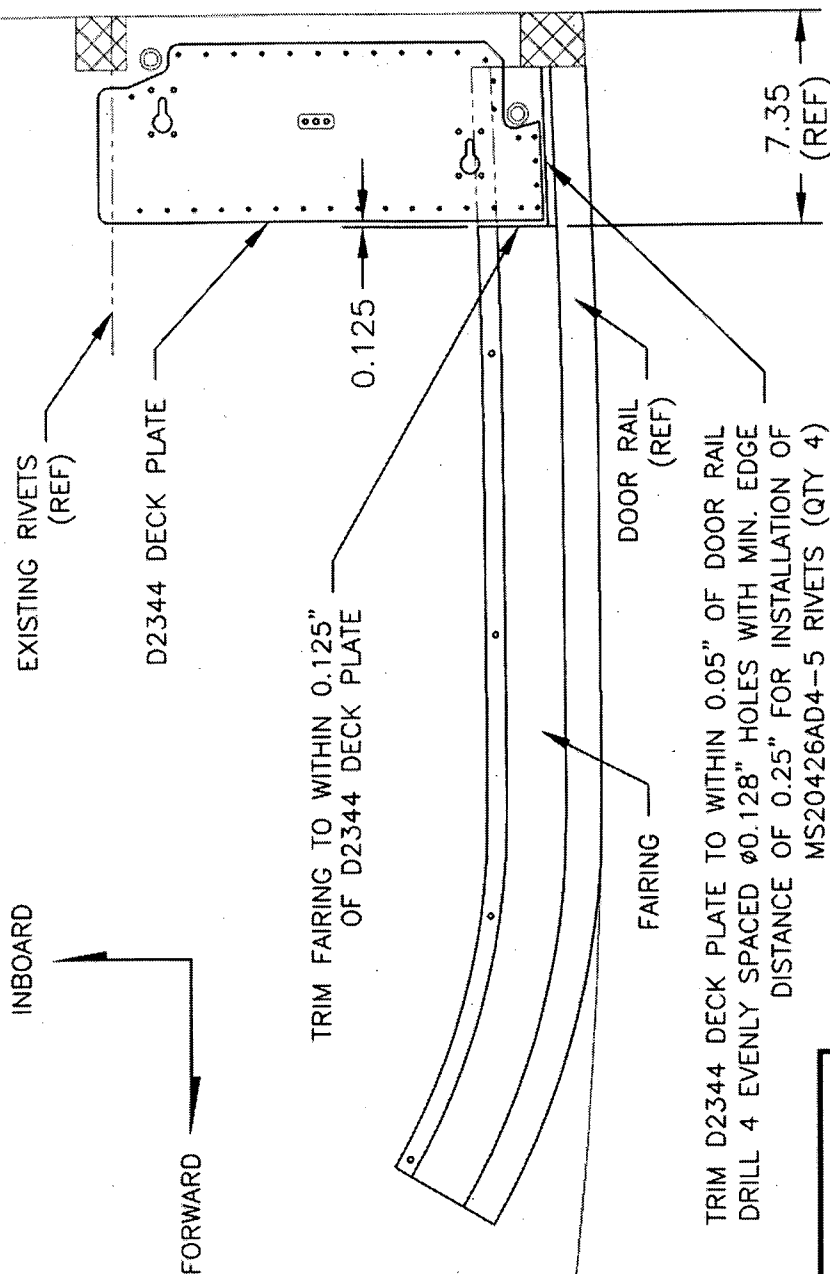
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COMPATIBILITY WITH SLIDING DOORS**FIGURE 11**

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